

Work Order ID 77489

December-08-11 1:40:46 PM

77489

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Item ID: D3996-FE-832-EF

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Self-Clinching Fastener

Start Date: 08/12/2011 Start Qty: 100.00

100

Cust Item ID:

Required Date: 15/12/2011 Req'd Qty: 100.00

100

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/12/08 Tooling:

Date:

Run Start ***NR1***

QC: _____

Date: _____ SPC (Y/N): _____

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3996

A

100

0.00

100

Purchasing

Purchasing

Memo

Issue P/O: 15069

Purchase Part Number: FE-832-EF

Supplier: Interfast Inc.

Certificate of conformity is required

0.00

CL 11/12/14 100

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Packaging

Memo

0.00

CL 11/12/14 100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77489

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Item ID: D3996-FE-832-EF Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Self-Clinching Fastener
 Start Date: 08/12/2011 Start Qty: 100.00 ***100*** Cust Item ID:
 Required Date: 15/12/2011 Req'd Qty: 100.00 ***100*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									

8 11/12/19 *(160)* *QSP019*

130	Identify as per dwg & Stock Location: <u>CA</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									

11/12/20 *(100)*

140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

11/12/20 *(100)*

11-12-20 *(100)*

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 77489

77489

Parent Item: D3996-FE-832-EF

D3996-FE-832-EF

Parent Item Name: Self-Clinching Fastener

Start Date: 08/12/2011

Required Date: 15/12/2011

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP RevA: new issue 09.11.11 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
FE-832-EF *FF-832-EF* PEM Insert		Purchased	No			110	Each	0.0000	1	100			
									**				

Rev 11/12/11 (200)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

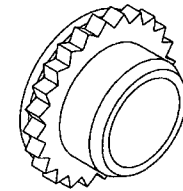
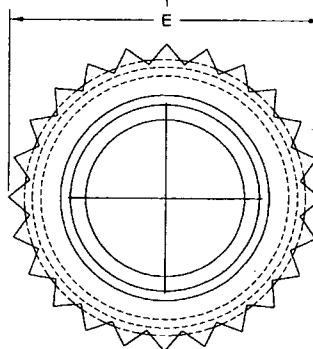
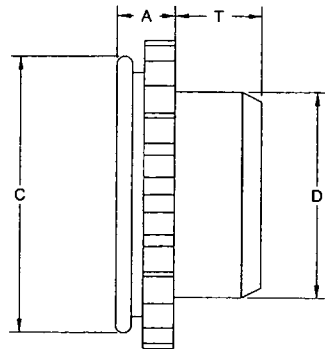
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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SPECIFICATION CONTROL DRAWING



D3996-XXX-YYY-ZZZ SELF-CLINCHING FASTENER

THREAD SIZE	THREAD CODE ("YYY")	TYPE ("XXX")	A MAX (SHANK)	SHEET THICKNESS	C +0.000 -0.005	D MAX	E ±0.005	T +0.015 -0.000	HOLE SIZE IN SHEET +0.003/-0.000	MIN DIST: HOLE CL TO EDGE	WEIGHT lb
#4-40 (0.112)	440	FEO	0.040	0.039-0.045	0.171	0.145	0.192	0.065	0.172	0.14	0.00031
		FE	0.060	0.059-0.070							0.00037
#6-32 (0.138)	632	FEO	0.040	0.039-0.045	0.212	0.180	0.244	0.075	0.213	0.17	0.00047
		FE	0.060	0.059-0.070							0.00068
#8-32 (0.164)	832	FEO	0.040	0.039-0.045	0.289	0.215	0.322	0.090	0.290	0.20	0.00098
		FE	0.060	0.059-0.070							0.00124
#10-32 (0.190)	032	FEO	0.040	0.039-0.045	0.289	0.245	0.322	0.110	0.290	0.20	0.00104
		FE	0.060	0.059-0.070							0.00120
1/4-28	0428	FE	0.060	0.059-0.070	0.343	0.318	0.384	0.120	0.344	0.28	0.00158

NOTES

1) SPECIFICATION: PENNENGINEERING (PEM) MINIATURE SELF-CLINCHING FASTENER, SELF-LOCKING
PEM P/N XXX-YYY-ZZZ

WHERE "XXX" = TYPE "FEO" (SHORT SHANK) OR "FE" (LONG SHANK) PER TABLE
"YYY" = THREAD CODE PER TABLE
"ZZZ" = FINISH CODE PER NOTE 2 BELOW

FOR EXAMPLE, #8-32 THREAD, LONG SHANK, ELECTRO-FILM FINISH:
DART P/N = D3996-FE-832-EF
PEM P/N = FE-832-EF

2) FINISH: FINISH CODE ("ZZZ") PER THE FOLLOWING:

"C" = CADMIUM YELLOW CHROMATE PER ASTM B766 CLASS 5 TYPE II
"CI" = CADMIUM CLEAR CHROMATE PER ASTM B766 CLASS 5, TYPE III
"EF" = ELECTRO-FILM PER MIL-PRF-46010
"MD" = MOLYBDENUM DISULFIDE DRY FILM (STD PEM FINISH)

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: N/A

7) WEIGHT: N/A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 37485 M.L.J.
11/12/08

RELEASED
2009-11-08

A	NEW ISSUE	DESCRIPTION	CP	09.10.01
REV.			BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	09.10.01			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3996	REV. A SHEET 1 OF 1
TITLE SELF-CLINCHING FASTENER	
SCALE NTS	
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W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO15669**

Purchase Order Date 12/14/11

PO Print Date 12/14/11

Page Number 1 of 1

Order From :

VC-INT001

INTERFAST INC.
6360 COTE DE LIESSE
MONTREAL, QC H4T 1E3
CA

Contact Name

Vendor Phone

5147385959

Vendor Fax

5147386363

Vendor Account Nbr

110900

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

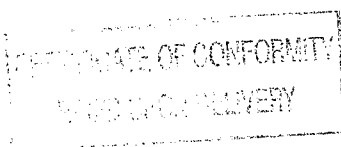
CL 11/2/11

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	FE-832-EF	PEM Insert	12/19/11 Yes	100.00 Each	FedEx PI collect	\$0.2200	\$22.00

Special Inst: AS PER DWG D3996 REV. A
B77489

PO Total:

\$22.00



CL

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 12/14/11



22 WORCESTER ROAD, TORONTO, ON, CAN, M9W 5X2
TEL: 1-416-674-0770 FAX: 416-674-5804
WEBSITE: www.interfast.ca

Packing Slip

PACK-SLIP REV: NC DATE: 09/30/03



Invoice#:

652028

4-DEC-11

SV DART AEROSPACE LIMITED
OE 1270 ABERDEEN ST.
LN HAWKESBURY ON
DD K6A 1K7
U CAN
T
OÀ

SE DART AEROSPACE LIMITED
HX 1270 ABERDEEN ST.
IP HAWKESBURY ON
PE CAN K6A 1K7
D
T
O
E
R
A

SHIP MODE: Purolator
MODE D'EXPEDITION:
FOB: FOB - Interfast Dock
F.A.B.
NO. CARTONS: 1
WAYBILL #: NAE100037139
FACTURE DE VOIE #:

CUSTOMER PO#:
N° DU BON DE COMMANDE: PO15669
CUSTOMER #: 110900
CLIENT #:
OUR SALE #: 564569
N° DE LA VENTE:
TERMS: Net 30 Days (L1)
MODALITES:

QUANTITY ORDERED QUANTITE COMMANDEE	U/M M.N.R.	QUANTITY SHIPPED QUANTITE EXPEDIEE	BALANCE DUE SOLDE	PART# & DESCRIPTION PARTIE # ET DESCRIPTION	LOT# / Serial#
100.00	EA	100.00	0.00	Cust PO Line#: Cust Part#: FE-832-EF Part#: FE-832-EF Description: NUT ** Packbox#: PACK558147 Lot Line#: 1 Qty: 100 Expire Date Country Of Origin: USA	D502640001
Harmonized code:		7318.16.00.90		Rev Lvl: Mfg/Cure Date:	

Total Qty Shipped: 100

GST/TPS # R102504958 QPST/TVQ #1009982431TQ0001

PAST DUE ACCOUNTS WILL BE SUBJECT TO A SERVICE CHARGE OF 1.5% PER MONTH. INTERFAST WILL BE RESPONSIBLE FOR THE AUTHORIZED REPLACEMENT OF GOODS WHICH ARE DEFECTIVE OR WHICH ARE NOT TO SPECIFICATION PROVIDED THAT CLAIMS ARE MADE WITHIN 14 DAYS OF SHIPMENT.

LES COMPTES EN SOUFFRANCE SERONT ASSUJETTIS À DES FRAIS DE SERVICE DE 1.5% PAR MOIS. INTERFAST NE SERA RESPONSABLE QUE POUR L'ÉCHANGE AUTORISÉ DE BIENS DÉFECTUEUX OU QUI NE SONT PAS CONFORMES AUX SPÉCIFICATIONS À CONDITION QUE LES RÉCLAMATIONS SOIENT EFFECTUÉES DANS LES QUATORZE (14) JOURS SUIVANT L'EXPÉDITION.

Dave Dawkins

Manager Of Quality



"I hereby certify that the items, or materials covered by this document have been inspected and tested and conform to all applicable specifications relative thereto, and unless authorized by customers, no work or alterations have been performed. Supportive documentary evidence of conformance is either on file or available upon request..

"Je certifie par les présentes que les articles ou matériaux couverts par le présent document ont été inspectés et testés, et qu'ils sont conformes à toutes les spécifications applicables en ce qui a trait auxdits articles ou matériaux. À moins d'avoir obtenu l'autorisation du client, aucun remaniement ni aucune modification n'ont été apportés. La documentation de soutien prouvant la conformité se trouve dans le dossier ou est disponible sur demande."

I hereby certify that the Aircraft Parts, Appliances and or materials described hereon were acquired from a source of supply that is consistent with the conditions under which the department of Transport Distributor approval No.178-94 has been granted certified by :